

M18745

Date: Tuesday, 5/8/2007 8:35:37 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 32240	
Estimate Number : 12812	
P.O. Number : <u>N/A</u>	Part Number : D3610# - 041
This Issue : 5/8/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3610 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 32130	Material : <u>N/A</u>
Written By : <u>JL 07.05.07</u>	Due Date : 5/15/2007 Qty: 20 Um: Each
Checked & Approved By : _____	
Comment : est rev A new issue 07.03.28 EC	
est rev B released, changed mat'l EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4140NB1500X15000	AISI 4140 Steel Bar
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Comment: Qty.: 0.5775 f(s)/Unit Total : 11.5500 f(s)  
 AISI 4140 Steel Bar

M103143

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank 6.600 " long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA692 Rev: AA & Dwg D3610 Rev: A

2-Deburr per dwg D3610.

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 32240

Part Number: D36101-041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



x20

Comment: SMALL & MEDIUM FAB RESOURCE 1  
1-C'SINK AS PER DWG D3610

ml 07/05/14

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/14

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

21 07-05-14

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/05/15

10.0

MS21075L3

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)  
Nutplate  
Batch: 18534

✓

11.0

MS20426AD34

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)  
RIVET  
batch: 102404

Pe 7/5/15 (20)

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Rivet Nut Plate as per Dwg D3610

ml 07/05/15 x20

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/15

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 32240

Part Number: D36101-ayl

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST1178*

*JP 7/5/15 50 (20)*  
*Level 21 inspection 07/05/15 (20)*  
*u 07.05.15*

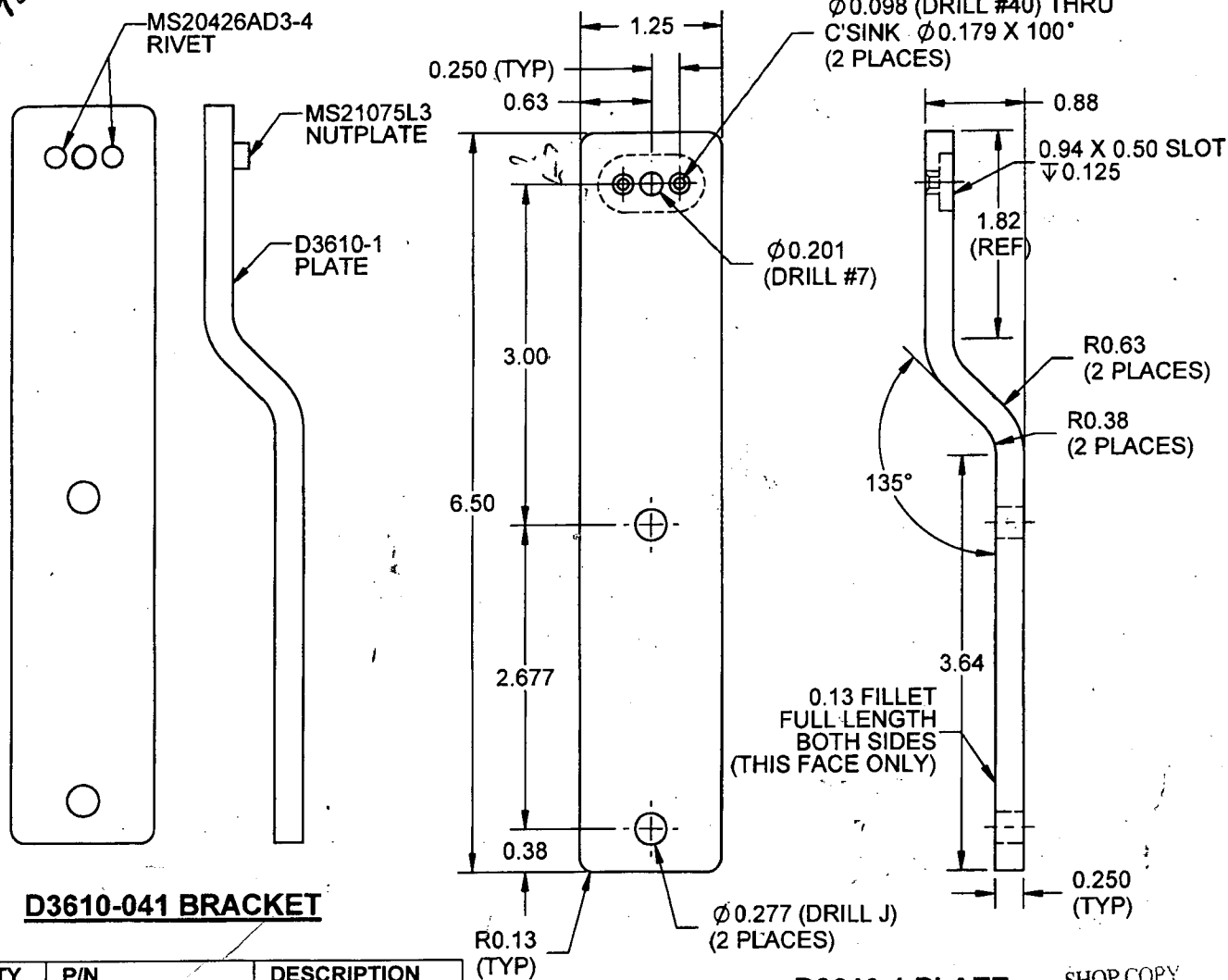
Job Completion





**DART**

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. <b>D3610</b>	REV. A SHEET 1 OF 1
DATE <b>07.04.20</b>	TITLE <b>BRACKET</b>	SCALE 2:3	
REV A	DATE 07.04.20	DESCRIPTION NEW ISSUE	

**D3610-041 BRACKET****D3610-1 PLATE**

QTY	P/N	DESCRIPTION
X	BRACKET	D3610-041
1	D3610-1	PLATE
1	MS21075L3	NUTPLATE
2	MS20426AD3-4	RIVET

**D3610-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3610-041" USING FINE POINT PERMANENT INK MARKER

**D3610-1 NOTES:**

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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RETURN TO

ENGINEERING

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07.04.20 SUBJECT AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 32130

DART AEROSPACE LTD		Work Order: 32130
Description: Bracket		Part Number: 3610-1
Inspection Dwg: D3610 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25"	±.030"	1.252"	✓			
.250"	±.010"	.252"	✓			
.63"	±.030"	.625"	✓			
6.50"	±.030"	6.501"	✓			
3.00"	±.030"	2.999"	✓			
2.677"	±.010"	2.680"	✓			
.38"	±.030"	.375"	✓			
Ø.098"	±.005"	Ø.098"	✓			
Ø.201"	±.005"	Ø.202"	✓			
Ø.277"	±.005"	Ø.280"	✓			
.88"	±.030"	.883"	✓			
.94"	±.030"	.936"	✓			
.50"	±.030"	.500"	✓			
▽ 0.125"	±.010"	▽.121"	✓			
.250"	±.010"	.254"	✓			
1.82"	±.030"	1.820"	✓			
3.64"	±.030"	3.640"	✓			
R.13"	±.030"	R.130"	✓			

Measured by: J.F.	Audited by: E	Prototype Approval: LE
Date: 07/05/11	Date: 07/05/11	Date: 07.05.11

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	